

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006002**Date Inspected:** 25-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi and Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly, Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**Bay 2**

ZPMC's qualified welding personnel's are identified as Mrs. Chen Hai Xia (045209), Mr. Zhang Yigui (048627), Mrs. Wang Chaili (045203), Mr. Yan Shitian (062708) and Mr. Liu Yujun (202654) perform FCAW welding on weld joint identified as SSD37-PP10-206 thru 205, SSD36-PP9.5-201 thru 207, FB060-001-30, 39 and FB062-001-45 and 44. ZPMC QC identified Mr. Hu Wei Qing was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

**Bay 3**

ZPMC's welding personnel's are identified as Mrs. Huang Xinlan (044280) performing groove welding of weld joint FB003-180-006. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Chen Xi and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with

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WPS-B-T-2221-G-12c-S-2.

ZPMC's qualified welding personnel's are identified as Mr. Liu Ming (044790) perform FCAW welding on weld joint identified as FB039-003-126 and 127. ZPMC QC identified Mr. Chen Xi was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-7C-P4-F.

Bay 6

ZPMC's qualified welding personnel's are identified as Mr. Lei Weiwen (019606) perform FCAW welding on weld joint identified as WD1-CBSA3-1-5-3, 4, 14, and 13. ZPMC QC identified Mr. Zhao Chen Sun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-P4-T-F-1.

Bay 7

ZPMC's qualified welding personnel's are identified as Mr. Zhao Shuming (046819) and Mr. Liu Yi (051019) perform SMAW (Tack) welding on weld joint identified as SP326-001-025,026 and SP326-001-027 and 028. ZPMC QC identified Mr. Wu Zhi Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-2314-7C-P5-2.

Bay 11

ZPMC's welding personnel's are identified as Mrs. Shen Mei (041716) and Cao Guimei (047304) performing groove welding of weld joint ESD1-FCSA3-2A/C-1A (1B), 2A (2B), 3A (3B) and ESD1-FCSA3-2B/C-46A. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Hong Wei and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-1.

ZPMC's qualified welding personnel's are identified as Mr. Xiao Ayong (070022), Mr. Zhong Chongli (068554), Mr. Fan Chenfu (0067501) and Mr. Liu Jin (202821) perform FCAW welding on weld joint identified as ESD1-FASA3-2E/E-62, 61, 32 and 31. ZPMC QC identified Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F.

ZPMC's qualified welding personnel's are identified as Mr. Li Xiuchun (040733) and Mr. Yang Lei (040690) perform SMAW (repair) welding on weld joint identified as ESD1-A165E/J-266B. ZPMC QC identified Mr. Wu Zhi Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

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### Bay 10

ZPMC's qualified welding personnel's are identified as Mr. Wang Kui (203977) and Mr. Yu Jun (201825) perform FCAW welding on weld joint identified as SSD1-FASA3-1E/G-22 and 23. ZPMC QC identified Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F.

### Bay 13

ZPMC's qualified welding personnel's are identified as Mr. Wang Quanlin (066746) perform FCAW welding on weld joint identified as SSD29-021thru 58. ZPMC QC identified Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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